

Work Order ID 61401

August 24, 2010 9:00:56 AM



Page 1

Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Latch Modification

Start Date: 8/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 9/07/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 10/8/24 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|--------------|--------------|
| INN-D350-589 | E |

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

S 10/08/30

HJ for BG 10-8-27

105

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SNIA 10/10/20

110

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S 10/08/30

(14)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 61401

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | Packaging | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per QSI 014 | | | | | | | | |
| | <i>Neu-F</i> | | | | | | | | |
| 130 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

*P 10/8/31 (4)**10/08/31**CL 10/8/31*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 24, 2010 9:00:56 AM

Page 1

Work Order ID: 61401

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F002.08.29 Removed D2587 Plug KJ
ALL AT CHANGE 002

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|---------------------|--------|
| AN960JD10 Washer | NAS1149D0363J | Purchased | No | | | 105 | Each | 6.0000 | 3 | 12 | | 11/15/07 10/18/2008 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST | | | | 6 | | | | | |
| | | | | | 107715 | | | 6 | | | | | |
| D2237 Striker Plate | | Manufactured | No | | | 105 | Each | 53.0000 | 3 | 12 | | 10/18/2008 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST009 | | | | 53 | | | | 12 | |
| | | | | | 58181 | | | 31 | | | | | |
| | | | | | 60492 | | | 22 | | | | | |
| D2583 Latch Bracket | | Manufactured | No | | | 105 | Each | 12.0000 | 3 | 12 | | 10/18/2008 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST017 | | | | 10 | | | | 10 | |
| | | | | | 60425 | | | 10 | | | | | |
| | | | | ST018 | | | | 2 | | | | | |
| | | | | | 56527 | | | 2 | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 24, 2010 9:00:56 AM

Page 2

Work Order ID: 61401

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 4.00

Required Qty: 4.00

D2585

Manufactured No

105

Each

67.0000

3

12

S
74 
Mounting Channel



10/8/26 SP

Location

Loc Qty

Loc Code

ST019

67

56524

1

59118

40

59873

26

12

D2586

Manufactured No


105

Each

50.0000

3

12

S
74 
Door Latch



10/8/26 SP

Location

Loc Qty

Loc Code

ST006

50

57917

50

12

D2587

Manufactured No


105

Each

28.0000

1

4

S
74 
Door Slug, 350 Hinge



10/8/26 SP

Location

Loc Qty

Loc Code

ST019

28

56555

28

4

D2589

Manufactured No

105

Each

197.0000

1

4

S
74 
Keys, Key Chain, 350 Hinge



10/8/26 SP (42)

Location

Loc Qty

Loc Code

ST019

197

58194

197

12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Picklist Print

August 24, 2010 9:00:56 AM

Page 3

Work Order ID: 61401

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-5 Purchased No

105 Each

1,141.000 6 24



Rivet, Universal Head



10/8/26 SP

Location

Loc Qty

Loc Code

ST309

1076

114761

1076

ST319

65

111916

65

24

MS21042L3 Purchased No

105 Each

2,340.000 3 12



Nut



10/8/20 SP

Location

Loc Qty

Loc Code

ST300

2340

114523

115

114718

225

114784

2000

12

MS27039-1-15 Purchased No

105 Each

97.0000 3 12



Screw



10/8/26 SP (40)

Location

Loc Qty

Loc Code

ST292

97

114056

2

114718

95

12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

REFERENCE ONLY

52.4 PARTS LIST

| 589 -011 | 589 -041 | 589 -042 | 589 -043 | Part Number | Description |
|-------------|-------------|-------------|-------------|--------------|-----------------------------------|
| X | | | | D350-589-011 | SIDE DOOR LATCH MODIFICATION KIT |
| | X | | | D350-589-041 | SIDE DOOR ASSEMBLY, LH AS 350 |
| | | X | | D350-589-042 | SIDE DOOR ASSEMBLY, RH AS 350/355 |
| | | | X | D355-589-043 | SIDE DOOR ASSEMBLY, LH AS 355 |
| | 1 | | | D2991-1 | Door |
| | | 1 | | D2991-2 | Door |
| | | | 1 | D2991-3 | Door |
| 3 | 3 | 3 | 3 | D2237 | Striker Plate |
| | 1 | 1 | 1 | D2464-1700 | Seal |
| 3 | | | | D2583 | Latch Bracket |
| 3 | 3 | 3 | 3 | D2585 | Latch Clamp |
| 3 | 3 | 3 | 3 | D2586 | Latch |
| 1 | | | | D2587 | Plug |
| 1 | 1 | 1 | 1 | D2589 | Keys, Key Chain |
| | 3 | 3 | 3 | D2621 | Latch Plate |
| | 2** | 2** | 2** | D2992-1 | Doubler |
| | 1 | 1 | 1 | D3085-041 | Prop Assembly |
| | 1* | 1* | 1* | D3015-3 | Locknut |
| | 1* | 1* | 1* | D3081-1 | Prop Hinge |
| | 1* | 1* | 1* | D3082-1 | Clip |
| | 1* | 1* | 1* | D3084-1 | Prop Arm |
| | 1* | 1* | 1* | AN4-5A | Bolt |
| | 3* | 3* | 3* | AN960JD10 | Washer |
| | 3* | 3* | 3* | AN960JD10L | Washer |
| | 2* | 2* | 2* | AN960JD416 | Washer |
| | 1* | 1* | 1* | AN960JD516L | Washer |
| | 3* | 3* | 3* | MS21042L3 | Nut (or MS21042-3) |
| | 1* | 1* | 1* | MS21042L4 | Nut (or MS21042-4) |
| | 3* | 3* | 3* | MS27039-1-13 | Screw |
| | 1* | 1* | 1* | SL69-BS | Ball Stud |
| | 6 | 6 | 6 | AN3-4A | Bolt |
| 3 | 3 | 3 | 3 | AN960JD10 | Washer |
| 3 | 9 | 9 | 9 | MS21042L3 | Nut (or MS21042-3) |
| 6 | 6 | 6 | 6 | MS20470AD4-5 | Rivet |
| 3 | 3 | 3 | 3 | MS27039-1-15 | Screw |

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00